

Date: Thursday, 12/13/2007 2:38:52 PM  
User: Kim Johnston

## **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 36321		
Estimate Number	: 10175		
P.O. Number	: N/A	Part Number	: D2570
This Issue	: 12/13/2007 S.O. No. : N/A	Drawing Number	: D2570 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 35130	Material	: N/A
Written By		Due Date	: 1/5/2008
Checked & Approved By	: JF 12.13	Qty:	500 Um: Each
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0750	303 Round Bar .75"	
			
Comment:	Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s)		
Material:	Ø0.750 AISI 303 SS Rod (M303R0.750)		
Batch	M106633 M106292		B.A. 07/12/24
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment:	HARDINGE CNC LATHE SMALL		
Machine as per folio FA198			
Deburr and tumble			B.A. 07/12/24
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
			H.A. 07/12/24
4.0	QC8	SECOND CHECK	
			
Comment:	SECOND CHECK		
			J.F. 07/12/31 (50)
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment:	PACKAGING RESOURCE #1		
Identify and Stock			
Location:	ST 42	overstocked	J.F. 01/02/08 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BUSHING
Job Number: 36321		Part Number: D2570
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE
		 501
Comment: FINAL INSPECTION/W/O RELEASE		D 08/01/03
Job Completion		<i>in 2008 1/2</i> <i>W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36321
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

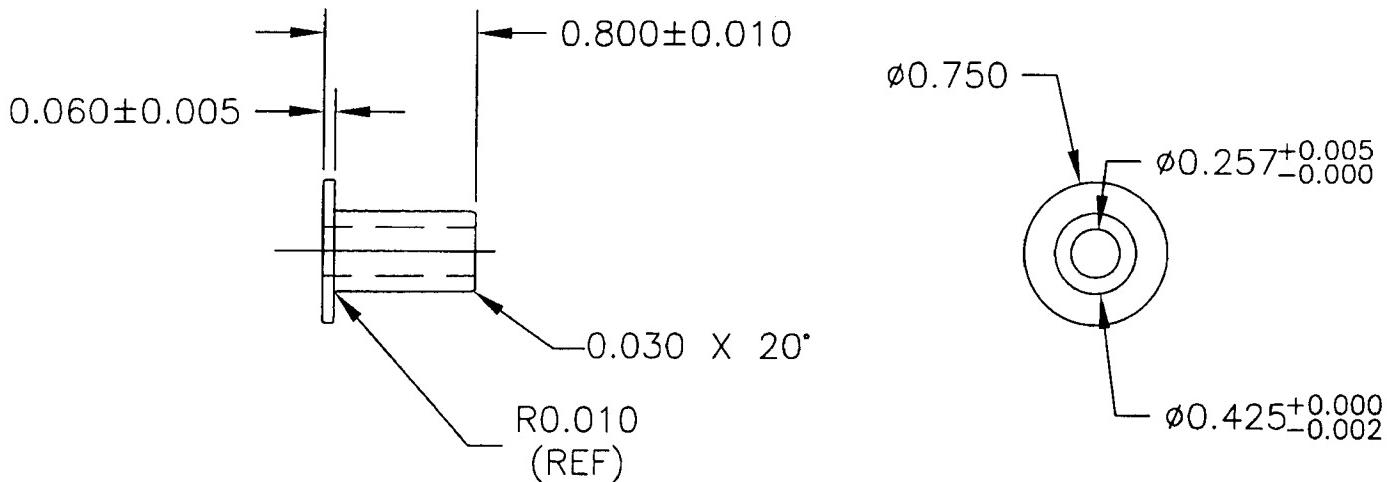
## X First Article      Prototype

Measured by:	<i>J.A./mz</i>	Audited by:	<i>SC</i>	Prototype Approval:	N/A
Date:	07/12/24	Date:	07/12/24	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	Z

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2570	REV. B	SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1	
A	96.09.16	NEW ISSUE		
B	07.04.17	UPDATE NOTES		

**RELEASED**  
07.06.28 *[initials]***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36321*

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